

# **DART SERVICE INSTRUCTION**

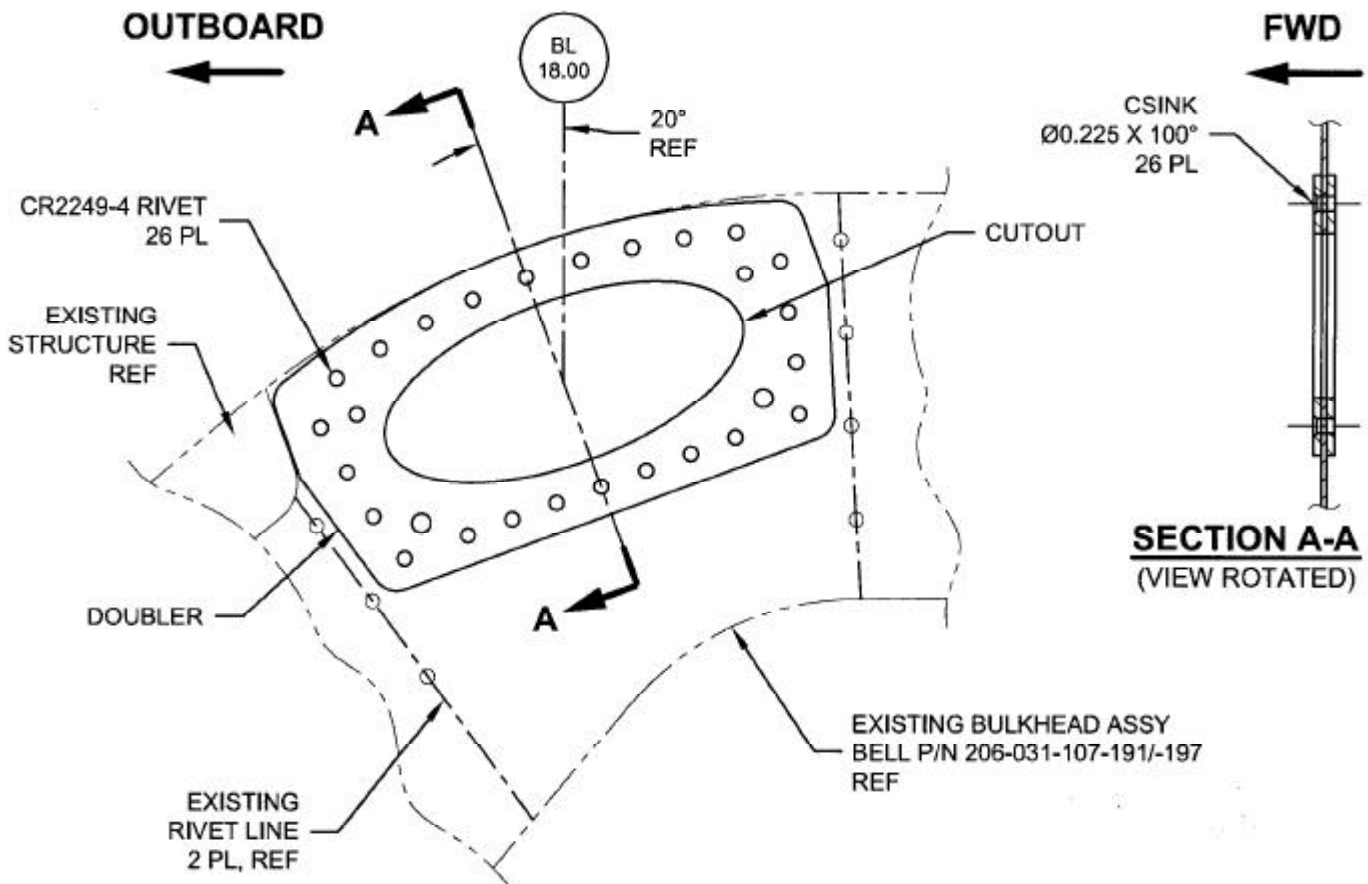
TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-746 REV. A

REF. CANADIAN STC: SH05-45

FAA STC: SH3367NM

EASA.IM.R.S.01449

TO MAKE THE DART D206-746-011 KIT COMPATIBLE WITH SOME BELL 206A/B AIRCRAFT, IT MAY BE NECESSARY TO CUTOUT AND REINFORCE THE BULKHEAD AT STA 121.19, LBL AND RBL 18.00 PER FIGURE 1. THIS CHANGE IS REQUIRED ON AIRCRAFT S/N 3568 AND SUBSEQUENT TO ENSURE THAT THE D206-746-041 REAR PASSENGER OVERHEAD MODIFICATION KIT CAN BE INSTALLED PER IIN-D206-746.



**FIGURE 1 - VIEW LOOKING AFT**  
(RH SHOWN, LH OPPOSITE)

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

**APPROVED**

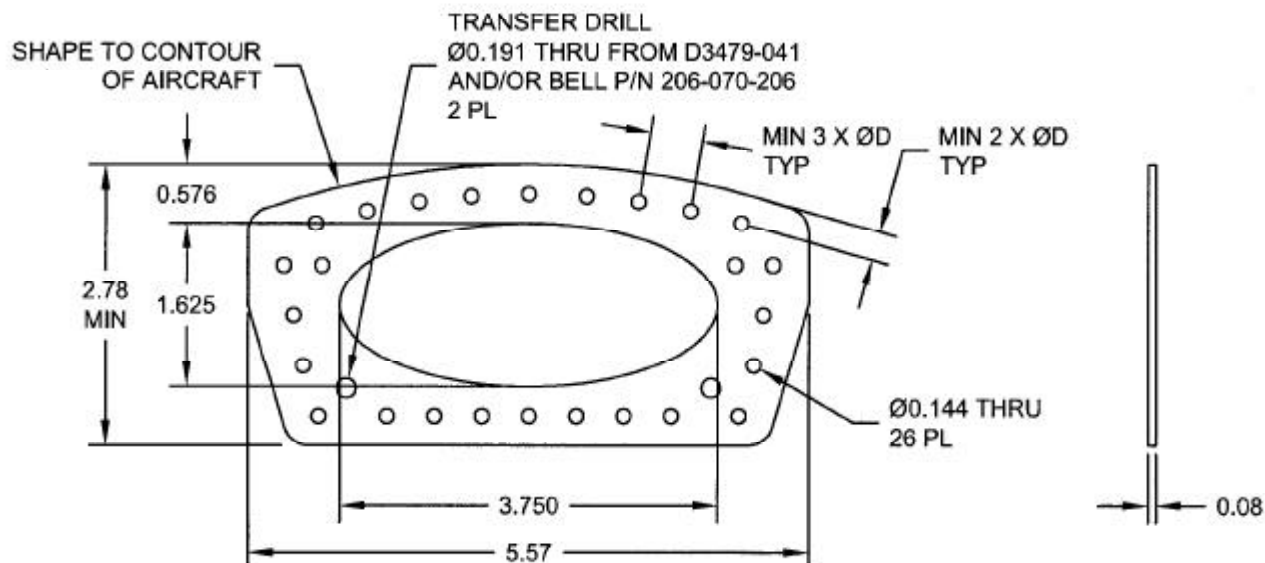
BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 08.10.30  
CERT. NO.: SH05-45  
ISSUE NO.: 1

A	NEW ISSUE	MB	08.10.30
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9426	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BULKHEAD MOD	NTS
DATE	08.10.30	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

## PROCEDURE

- 1) MAKE DOUBLERS PER FIGURE 2 OF THESE INSTRUCTIONS. COUNTERSINK Ø0.144" HOLES ON ONE DOUBLER ONLY WHICH WILL BE INSTALLED ON THE FORWARD FACE OF THE BULKHEAD PER FIGURE 1.
- 2) LOCATE DOUBLERS PER FIGURE 1 OF THESE INSTRUCTIONS.
- 3) TRANSFER ELLIPTICAL CUTOUT, Ø0.144" RIVET HOLES AND Ø0.191" FASTENER HOLES FROM DOUBLER TO THE BULKHEAD. DEBURR.
- 4) TOUCH UP AFFECTED AREAS ON BULKHEAD IN ACCORDANCE WITH AIRCRAFT MAINTENANCE MANUAL.
- 5) INSTALL THE DOUBLERS AS SHOWN IN FIGURE 1 OF THESE INSTRUCTIONS. APPLY A LAYER OF PROSEAL 890 OR MIL-S-8802 CLASS 'B2' SEALANT BETWEEN DOUBLERS AND AIRCRAFT SKIN.
- 6) INSTALL DUCT ASSY BELL P/N 206-070-204 AND FLANGE ASSY BELL P/N 206-070-206 IN ACCORDANCE WITH AIRCRAFT MAINTENANCE MANUAL.
- 7) COMPLETE INSTALLATION OF D206-746-041 REAR PASSENGER OVERHEAD MODIFICATION KIT PER IIN-D206-742 REV. A AND INSTALLATION DRAWING D206-746 REV. A.



## FIGURE 2 NOTES:

- 1) MATERIAL: 2024-T3 X 0.080" THICK ALUMINUM SHEET PER AMS-QQ-A-250/4 OR AMS 4037
- 2) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 3) FINISH: APPLY CHEMICAL FILM COAT OF ALODINE 1200/1201 PER MIL-C-5541.  
APPLY ONE COAT OF MIL-P-85582/MIL-P-23377 PRIMER AND AT THE INSTALLER'S DISCRETION 2-3 COATS OF MIL-C-83285 POLYURETHANE PAINT TO MATCH FINISH AND COLOR OF AIRCRAFT.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED




## FIGURE 2 - DOUBLER DETAIL

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 08.10.30  
CERT. NO.: SH05-45  
ISSUE NO.: 1

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		<b>HAWKESBURY, ONTARIO, CANADA</b>	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9426	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BULKHEAD MOD	NTS
DATE	08.10.30	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			